

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029504**Date Inspected:** 02-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

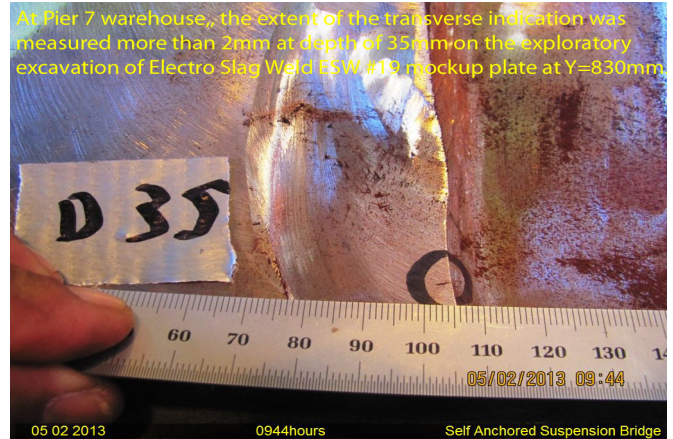
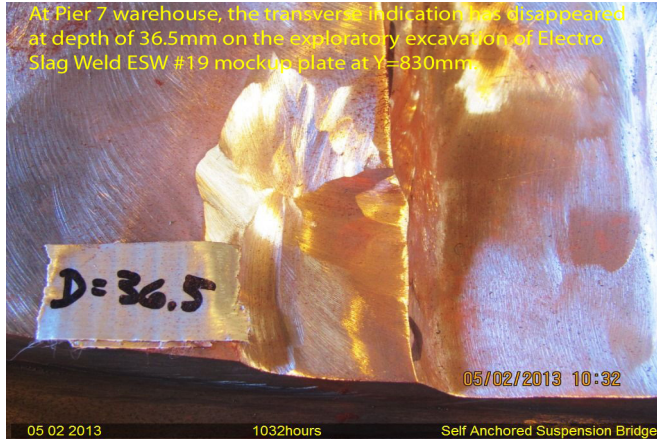
At Pier 7 warehouse, this QA together with ABF QC Bernie Docena have observed the exploratory excavation of Ultrasonic Testing (UT) detected defect on welded mock up plate ESW #19 Electro Slag Weld (ESW). ABF personnel was observed continuing to perform exploratory excavation on welded ESW at location Y=830mm where the transverse indication was found. The ABF personnel have resumed the exploratory excavation from 34mm deep with 1mm increments. The personnel were noted using only the disc grinder in every 1mm increments of excavation to the side of the transverse indication. ABF QC Bernie Docena was observed performing Magnetic Particle Testing (MT) on every depth of excavation with same 2-3mm transverse indication noted so far. This QA also performed the same test at every depth and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 36.5mm before the transverse indication had disappeared. After the disappearance of the indication, SMR Aaron Prclich was informed. The shift was completed up to this depth of excavation.

The results of the exploratory excavations are as follows;

1. 34mm in depth – 2 – 3 mm transverse indication noted.
2. 35mm in depth – 3mm transverse indication noted.
3. 36.5mm in depth – no significant indication noted. Transverse indication has disappeared.

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Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer